

Date: Monday, 11/6/2006 2:41:12 PM
User: Kim Johnston

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 29364	Part Number	: D3492043
Estimate Number	: 12337	Drawing Number	: D3492 REV B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/6/2006 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : MACHINED PARTS	Due Date	: 11/28/2006
Previous Run	: 29045	Qty:	80 Um: Each
Written By	: <u>JA 06/11/07</u>		
Checked & Approved By	: <u>JA 06/11/07</u>		
Comment	: Est Rev: A 06-03-21 New Issue JLM : Est Rev: B 06-08-28 As per Rev B JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6R0750	6061-T6 Round Bar .750"
-----	--------------	-------------------------



Comment: Qty.: 0.0656 f(s)/Unit Total : 2.6250 f(s) 5.25 *
6061-T6 Round Bar .750"
(M6061T6R750)
Batch: 19430 BG 06.11.07

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA632 & Dwg D3492
Dwg Rev: B
Folio Rev: AA

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE 06.11.07 BG 80

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK J.G 06/11/14 80

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD 06.11.20 80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: FP Date: 07/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:41:13 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 29364

Part Number: D3492043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

glam 06/11/21 x80

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

a.m 06/11/29 (x80)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/01/10 counted (79)

9.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-013 O-RING

101519 x48

FC 07 01 10 (48)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube
A/R 55-O'Ring Lube Batch: *101223*

FC 07 01 10 (48)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07 01 11 48

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FP 15 ml 07 01 11 (48)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(48) 07/01/11 u 07-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

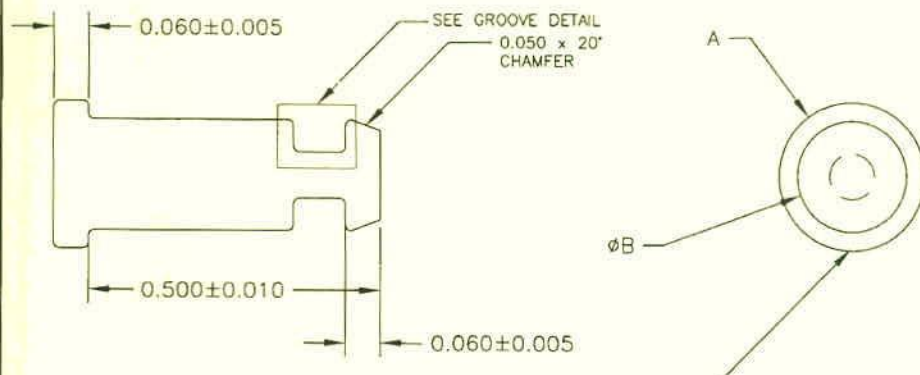
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

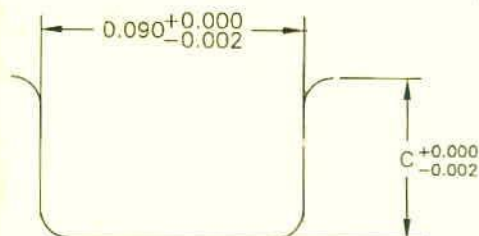
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1



GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500

B

D3492-1/-3/-5/-7 PLUG NOTES

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.DDD)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- BREAK ALL SHARP CORNERS 0.010 MAX

WORK ORDER
 NO. 29364
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 RETURN TO
 ENGINEERING
 SHOP COPY

D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2

NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

D3492-041/-043/-045 PLUG ASSEMBLY

RELEASED
 06.10.02 894
 PER ELM #351

D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST
 (TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D3492-041	PLUG ASSEMBLY
	X			D3492-043	PLUG ASSEMBLY
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING

B

B

B		06.05.11	ADD -047; UPDATE DIM A, -045
A		06.01.04	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HENLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3492	SHEET 1 OF 1
DATE	TITLE	SCALE	NTS
06.05.11	PLUG		

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
 AND IS SUPPLIED ON THE EXPRESS CONDITION
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE
 OR COPIED OR COMMUNICATED TO ANY OTHER
 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE USA, INC.

